



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3272-1

Job Sheet 181603



Part No: D3272-1

Job Qty: 5 ea 10

DAS
21
9-88

Part Name: Step



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: 8/15/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV B IPP Rev:A New Issue 07-06-09 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	5 Ea		8/15/18	0.00	0.00	Start Up Large Fab-4		SLN
100	Large Fab	5 pcs		8/15/18	0.00	2.33	Large Fab 8		SLN
110	QC	5 pcs		8/15/18	0.00	0.00	QC5		CPC
120	Packaging	5 pcs		8/15/18	0.00	0.00	Packaging3 Large Fab		DAS NOV 9 0 2018
130	QC21-SA	5 Ea		8/15/18	0.00	0.00	QC21		21 NOV 20 2018

Part Op 100 - ***SQUARE ONE END BEFORE CUTTING OTHER END*** 1-Cut D2622-120 extrusion to 116.25" long as per Dwg
Descriptions: D3272 using cutting table setup DT 8185-2A 2-Drill extrusion as per Dwg D3272 using Jig DT8680 for rivets. 3-Deburr
120 - LOCATION: WA003

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	5 Ea (1 ea)	90-Start up Operation	5104007

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2622-120C	5	3	0

Part Specifications

Specifications could not be found.

6548

Plex 8/1/18 1:57 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																																																																				



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

18-08-01
NO. 181603 MS
WORK ORDER
WITHOUT NOTICE
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SUBJECT TO AMENDMENT
ENGINEERING
RETURN TO
SHOP COPY

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

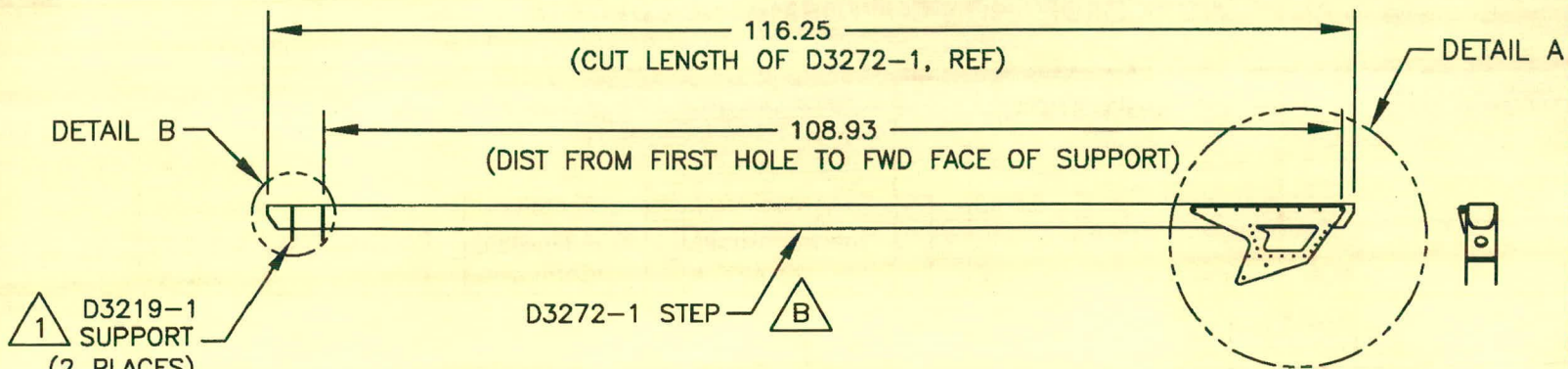
QA Closed: _____ Date: _____

Work Order update only ☐

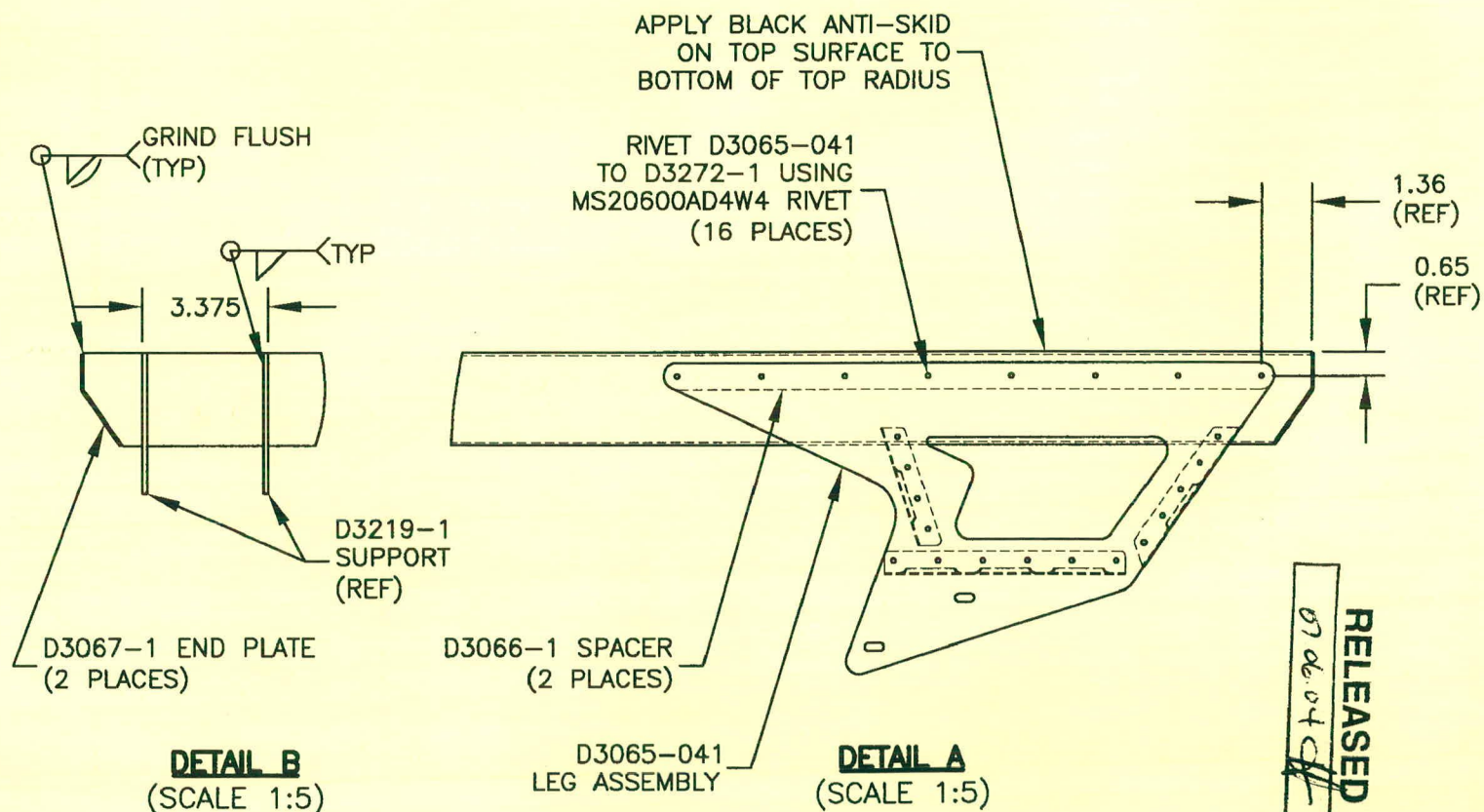
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. B
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE	TITLE	DRAWING NO.	SHEET 2 OF 3
07.05.18	STEP ASSEMBLY, HI LONG	D3272	SCALE
			1:20



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

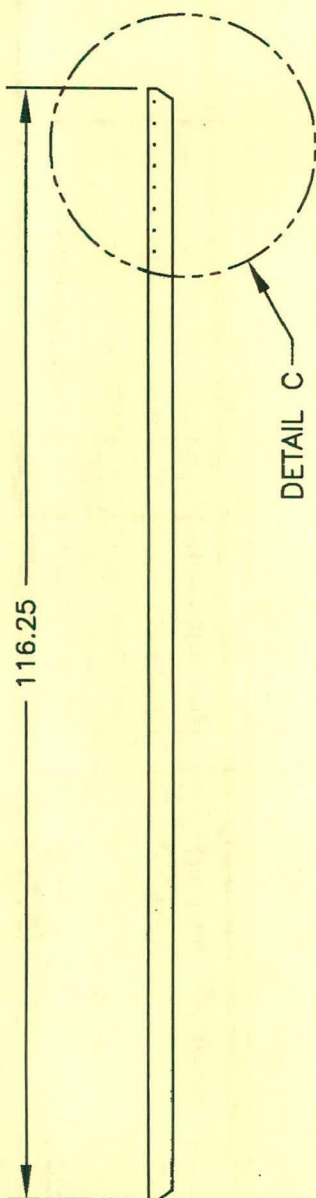
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Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								



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CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

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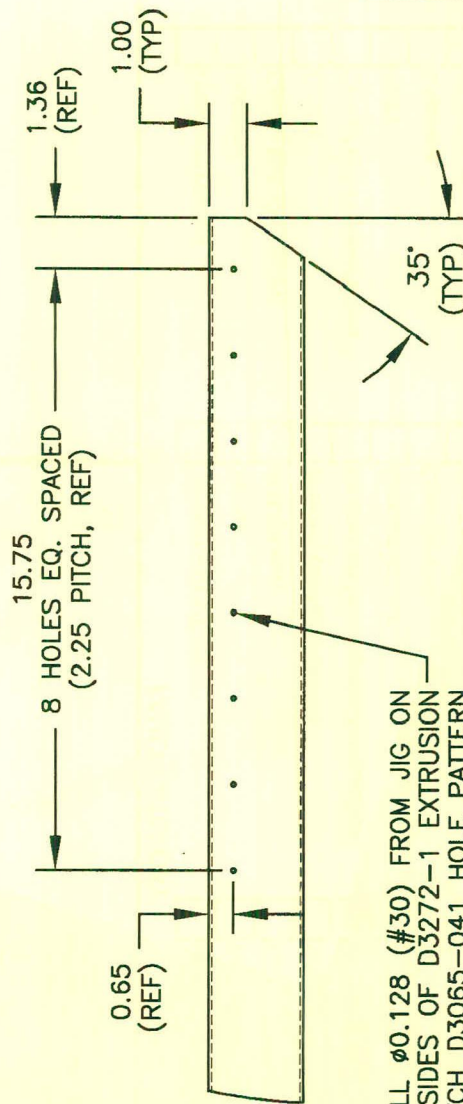
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
Part: D3272-1 Job No: 181603 Serial No/ Batch: S129268 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various S/C's Container No: S129268 Part: D3272-1 Job No: 181603 Serial No/ Batch: S129268 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various S/C's 1270 Aberdeen Street Haverhill, MA 01830 Tel: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com				QC / QA Coordinator Approval	
				Lead hand / Supervisor Approval Verification	
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OTHER : _____					